

Work Order ID 58895

May 20, 2010 10:46:38 AM



Page 1

Item ID: D3696-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm Assembly

Start Date: 5/19/10

Start Qty: 6.00

3



Cust Item ID:

Required Date: 5/28/10

Req'd Qty: 6.00

3



Customer:

Reference: Rework

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3696	Rev C

171		0.00							
	Mill Conv								
	Conventional Milling Machine								
	Memo	0.00							
	DRILL/COUNTERSINK HOLE PER								
	DRWG D3696 REV.D, PER ECN10-573								

TO

10/12/02

3

172		0.00							
	QC								
	Quality Control								
	Memo	0.00							
	QC2- Inspect parts off machine FAI/FAIB								

AA

10/12/02

3

173		0.00							
	QC								
	Quality Control								
	Memo	0.00							
	QC8- Inspect parts - second check								

GA

10/12/02 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3696-041 PAR #: _____ Fault Category: machining NCR: Yes No DQA: [Signature] Date: 10/12/02
 Resolution: Accepted Disposition: USE AS IS QA: N/C Closed [Signature] Date: 10/12/07

NCR: <u>58895</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/02	171	C'BORE on one Arm Assy is .008 beyond tolerance actual .318 Dwg. .300 DP. P.C. PROCESS - manually done.	<u>[Signature]</u> 10.12.02 Q51042	ACCEPTABLE DEVIATION. C'BORE REQ'D FOR CLEARANCE OF JUT.	<u>[Signature]</u> 10/12/02	B.A 10/12/02	<u>[Signature]</u> 10.12.02 Q51042	<u>[Signature]</u> 10/12-02
10.12.02	171	9.500 DIA IS 9.475 TO 9.488. P.C. MANUAL/PROCESS	<u>[Signature]</u> 10.12.02 Q51042	ACCEPTABLE. ON THE BASIS THAT THE SYSTEM OFFERS ENOUGH PLAT TO MATE/ FASTEN PARTS.	<u>[Signature]</u> 11/12/02	H.A 10/12/02	<u>[Signature]</u> 10.12.02 Q51042	<u>[Signature]</u> 10/12-02

NOTE: Date & initial all entries

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Item ID: D3696-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Arm Assembly

Start Date: 5/19/10 Start Qty: 6.00

Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 6.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location <u>262</u>	0.00							
Packaging	Memo	0.00							
Packaging	RE-STOCK USING NEW B/N								
200 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/3 (50) SP

10/12/07

MF

10-12-03

Picklist Print

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Work Order ID: 58895



Parent Item: D3696-041



Parent Item Name: Arm Assembly

Start Date: 5/19/10

Required Date: 5/28/10

Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC
IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP
REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D3696-041		Manufactured	No				Each	8.0000				



Arm Assembly



Location

Loc Qty

Loc Code

ST205

2

44542

2

ST255

6

56900

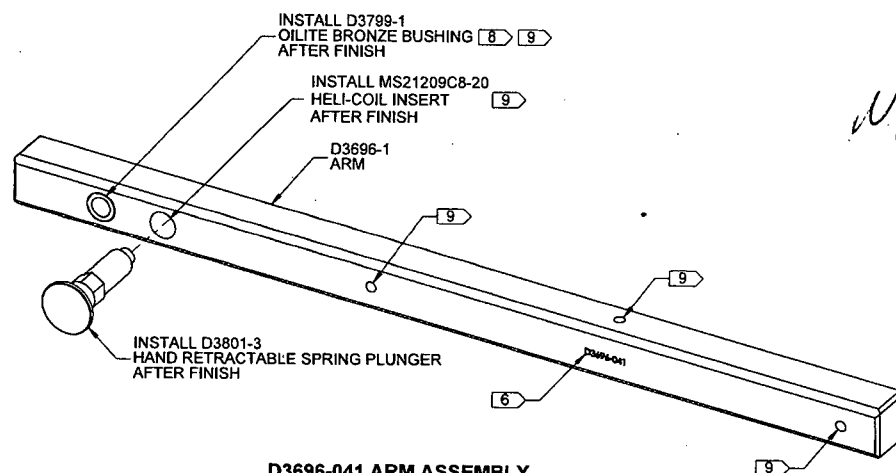
2

58010

4

AD 10/12/02

ITEM	QTY	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



D3696-041 ARM ASSEMBLY

RELEASED
2010-05-17
AMP

D3696-041 NOTES:

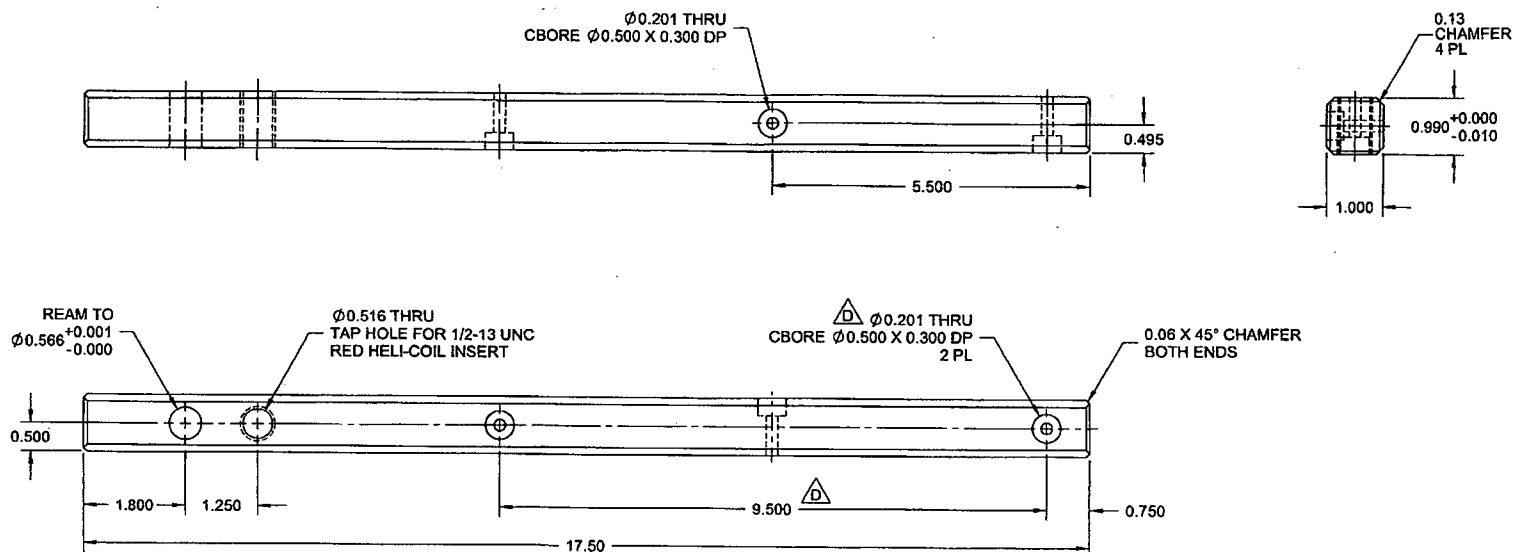
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.68 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

D	REVISED ITEM 5 AS FOLLOWS: 'Ø0.201 THRU CBORE Ø0.500 X 0.300 DP' NOW 2 PL (ZN C4-2 AND B4-2). REASON: ADDITION OF ALTERNATE ARMREST INSTALLATION D412-761-051 BASED ON FEEDBACK FROM END USERS AT HAI 2010	MB	10.05.06
C	REVISED ITEM 5 AS FOLLOWS: 'Ø0.201 THRU CBORE Ø0.500 X 0.300 DP' WAS 2 PL (ZN C4-2). REASON: REDESIGNED ARMREST CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D6-1); P/N D3801-3 WAS PRT-12 (ZN C7-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS: ADDED Ø0.201 HOLE AND CBORE (ZN C6-2 AND D6-2); 17.50 WAS 19.50 (ZN B6-2); 1.000 WAS 0.990 +0.000/-0.010 (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	1.6		
DRAWN	1.6		
CHECKED	1.6		
MFG. APPR.	1.6		
APPROVED	1.6		
DE APPR.	1.6		
DATE	10.05.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3696** REV. D
SHEET 1 OF 2
TITLE **ARM ASSEMBLY** SCALE NTS

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D3696-1 ARM

RELEASED
2010-05-17
AM

D3696-1 NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/B (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11
REF. DART SPEC. M7075T6B
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.62 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3696	REV. D
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE ARM ASSEMBLY	SCALE
DE APPR.			NTS
DATE	10.05.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

List Lots

November 16, 2010 7:23:25 AM

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Criteria : Item ID: d3696-041 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D3696-041	Main Warehouse	44542	5/20/10	2.0000			
Arm Assembly	ST205						
	Main Warehouse	58010	9/24/10	3.0000	QC21	AO	10/12/02 3
	ST255						
			Total:	5.0000			